

Work Order ID 100412

100412

Page 1

April-22-13 1:15:36 PM

Item ID: D4017-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rib

Stop *NS2*

Start Date: 4/30/13 Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/30/13 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:	Process Plan: <u>ML5</u>	Date: <u>13-04-23</u>	Tooling:	Date:	Run	Start	*NR1*
QC:		Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4017	D								
100		0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D4017 2- Deburr and remove identify marks								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location:	0.00							
120									
Packaging	Memo	0.00							
Packaging									

x10 13-07-08 MAC

10x 13-07-08

10x 13-07-08

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION			AGAINST DEPARTMENT/PROCESS															
Part No. _____		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
NCR No. _____	Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description			Sign & Date	Verification	QC Inspector							
Doc/Data																				
Equip/Tooling																				
Operator																				
Material																				
Setup																				
Other																				
Process																				
Supplier																				
Training																				
Unapproved																				
FAULT CATEGORY																				
Landing Gear					General															
Bending		Bend			Grain			Ovalized		Pressure/Forced										
Centre Not Concentric to O/S		BOM/Route			Hardware			Over/Under tolerance		Temperature/Cure										
Cracks		Broken/Damaged			Inspection Incomplete			Part Incorrect		Weld										
Crushed/Crimped		Burrs			Instructions Incomplete/Unclear			Part Lost/Missing		Wrong Stock Pulled										
Cuffs		Contamination			Maintenance			Part Moved												
Heat Treat		Countersink			Mislabeled			Positioned Wrong												
Inspection Strip in Tube		Cut Too Short			Misread			Power Loss/Surge		Other										
Ripples in Bend		Drill Holes			Offset															
Torque Waves in Extrusion		Drawing			Out of Calibration															
Turning Sequence		Finish			Out of Sequence															
Wave/Twist in Tube		Folio			Outside Dimensions															

Work Order ID 100412

April-22-13 1:15:36 PM

100412

Page 2

Item ID: D4017-7

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 4/30/13 Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/30/13 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

13/7/94

Memo

0.00

AB-07-8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge					
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							

Picklist Print

April-22-13 1:15:35 PM

Page 1

Work Order ID: 100412

Parent Item: D4017-7

Start Date: 4/30/13

Required Date: 4/30/13

Parent Item Name: Rib

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg RevA DD
10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 11.01.18 chg qc5 to 6 DD
verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	970.7307	0.0675	0.2131578			

Location	Loc Qty	Loc Code
MAT017	241.6869	
124492	241.6869	
WA006	729.0438355	
123219	16.0438355	
123484	113	
125124	600	

125579

0.6770

13-07-08MA

NCR: Yes / No

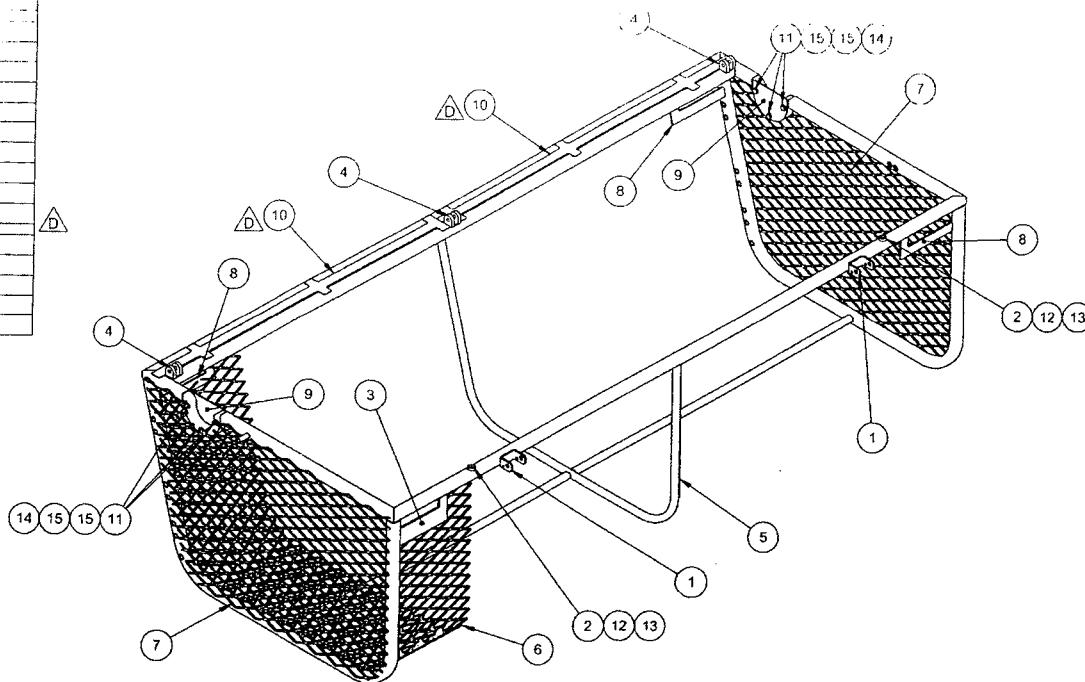
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>		
				BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
				Cracks <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>			
				Crushed/Crimped <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
				Cuffs <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
				Heat Treat <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
				Inspection Strip in Tube <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>			
				Ripples in Bend <input type="checkbox"/>	Offset <input type="checkbox"/>					
				Torque Waves in Extrusion <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
				Turning Sequence <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					
				Wave/Twist in Tube <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>					

ITEM	QTY	P/N	DESCRIPTION
X	1	D4017-041	SHORT BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	3	D4016-1	HINGE HALF, BASE
5	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-3	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

100412 MLS
13-04-23

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 28.8 lbs APPROX
 - 8) INSTALL AFTER FINISH
 - 9) MASK HOLES PRIOR TO POWDER COAT
 - 10) WELD PER DART QSI 004

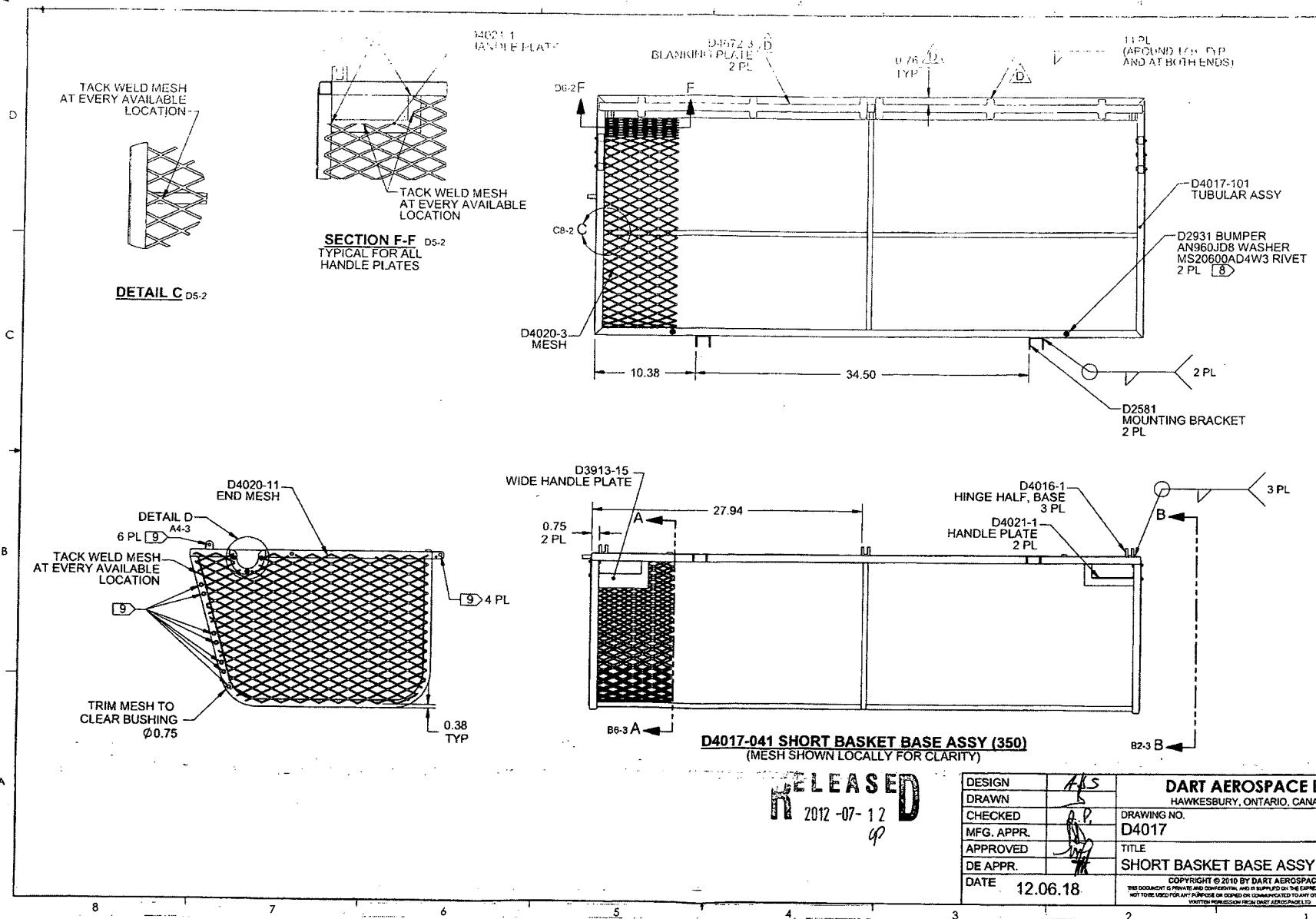
RELEASED
2012-07-12

OP ECN R-60

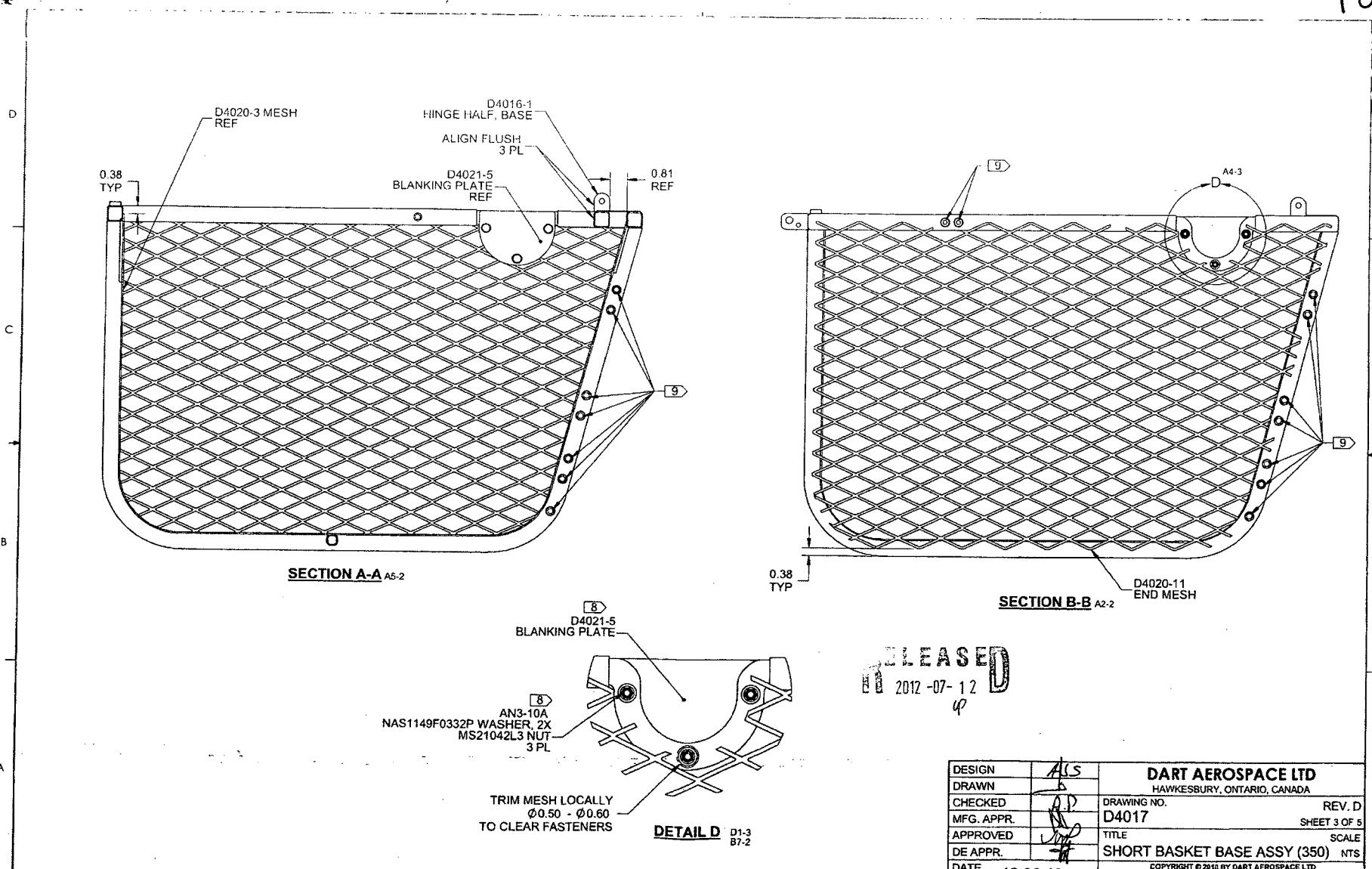
D	ADD D4672-3 (ZN C5-1, D4-1, D6-1, D3-2, AND D4-2). REASON: PAR12-197.	MB	12.06.18
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D5-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15 AN3-10A BOLT WAS AN3C10A. NAS1149F0332P WASHER WAS NAS1149C0332P. SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3).	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION		
DESIGN	AJS		
DRAWN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	REV. D		
MFG. APPR.	D4017		
APPROVED	TITLE SHORT BASKET BASE ASSY (350) NTS		
DE APPR.	SCALE COPRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE, EXCEPT AS AUTHORIZED BY DART AEROSPACE LTD. WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	12.06.18		

8 7 6 5 4 3 2 1

100412



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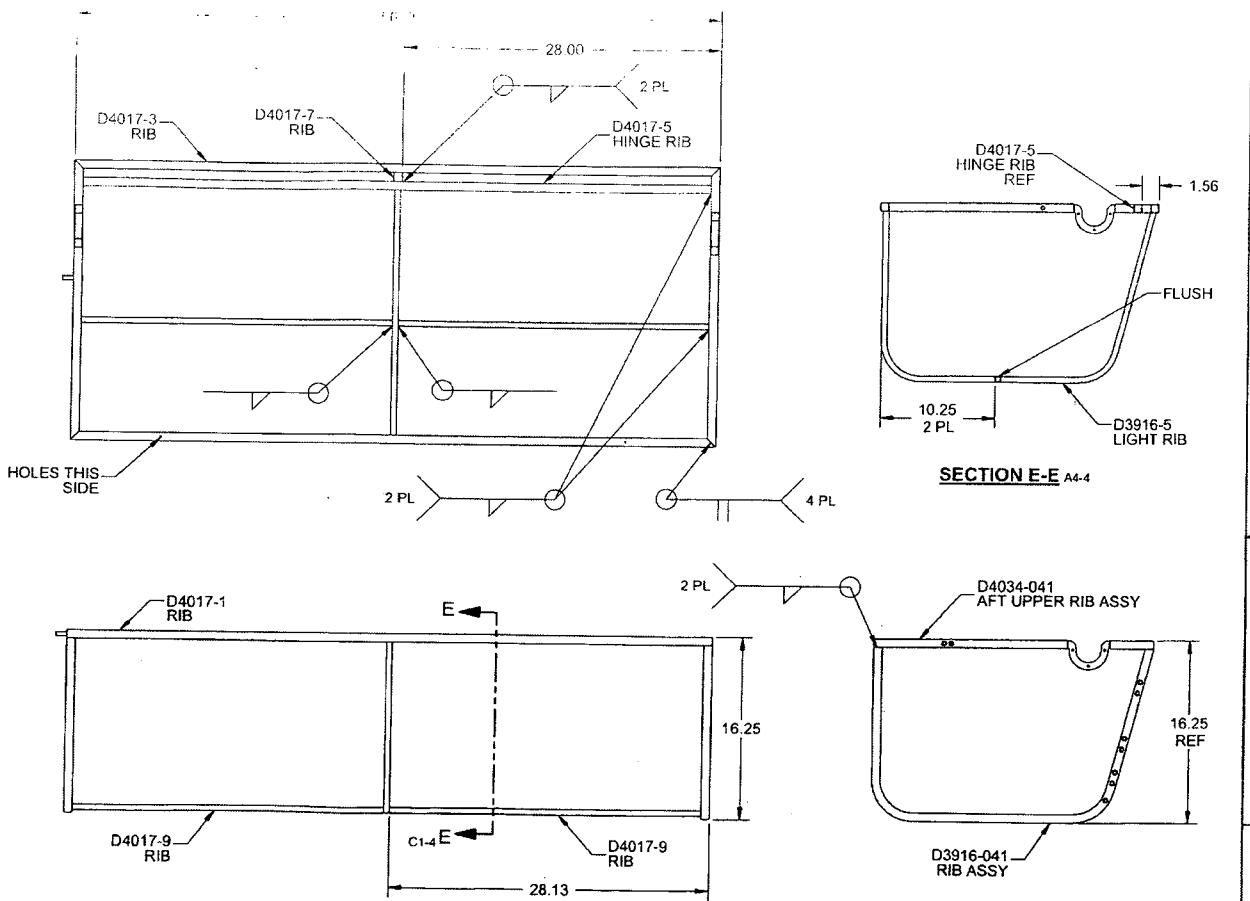
RELEASED
2012-07-12
4P

DESIGN	ALS	DART AEROSPACE LTD
DRAWN	b	HAWKSLEY, ONTARIO, CANADA
CHECKED	PD	REV. D
MFG. APPR.	(Signature)	D4017
APPROVED	(Signature)	SHEET 3 OF 5
DE APPR.	(Signature)	TITLE
DATE	12.06.18	SCALE
		SHORT BASKET BASE ASSY (350) NTS

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100412

ITEM	QTY	DESCRIPTION
X	1	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4117-1 RIB
2	1	D4017-3 RIB
3	1	D4017-5 HINGE RIB
4	1	D4017-7 RIB
5	2	D4017-9 RIB
6	2	D3916-041 RIB ASSY
7	1	D3916-5 LIGHT RIB
8	1	D4034-041 AFT UPPER RIB ASSY
9	1	D4034-043 FWD UPPER RIB ASSY



⑧ D4017-101 TUBULAR ASSY (350 SHORT BASKET)

RELEASED
2012-07-12
vp

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 7 1 6 5 4 3 2 1

DESIGN	ALS
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	12.06.18

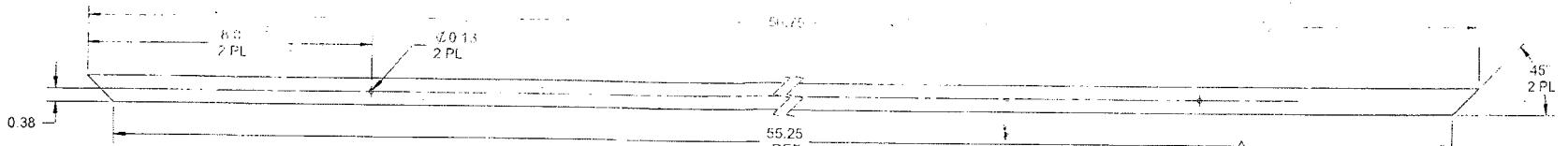
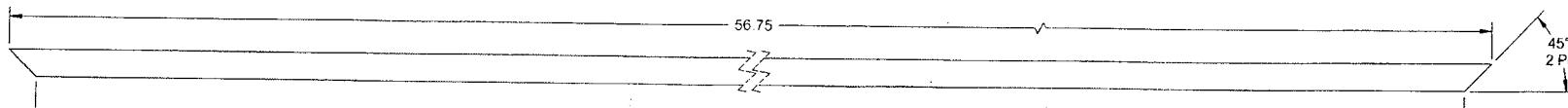
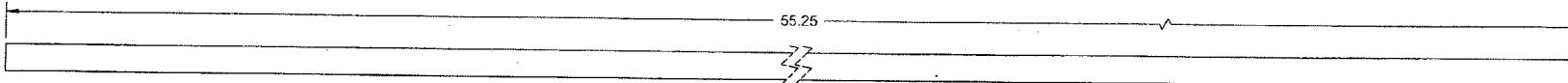
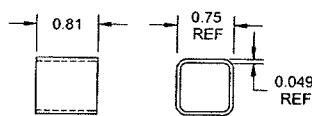
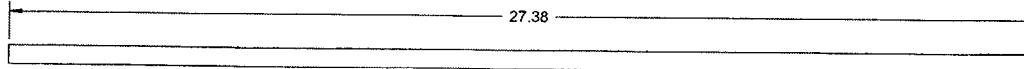
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4017 REV. D
SHEET 4 OF 5

TITLE SHORT BASKET BASE ASSY (350) NTS

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160412

D4017-1 RIBD4017-3 RIBD4017-5 HINGE RIBD4017-7 RIBD4017-9 RIB

NOTES:

- 1) MATERIAL -1 THRU -7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2012-07-12
IP

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>A.0.</i>	REV. D
MFG. APPR.	<i>RP</i>	DRAWING NO. D4017 SHEET 6 OF 5
APPROVED	<i>JW</i>	TITLE SHORT BASKET BASE ASSY (350) NTS
DE APPR.	<i>RP</i>	SCALE COPRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED, NOR IS IT TO BE COPIED WITHOUT PERMISSION FROM DART AEROSPACE LTD.
DATE	12.06.18	